Work Order ID 122661 *122661* Page 1 Tuesday, July 22, 2014 8:42:55 AM Item ID: D3564-13 Accept *N900040100* Setup Start **Revision ID:** Stop Stainless Steel Wearpad Fwd **Item Name:** *12* **Start Qty: 12.00 Start Date:** 7/21/14 **Cust Item ID:** Required Date: 7/21/14 Reg'd Oty: 12.00 *12* **Customer:** Reference: Start Run Date: 14-07-23 Tooling: **Approvals:** Process Plan: MLJ Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID Description** Qty Number Qty Stamp **Run Hours** Code **Draw Nbr Revision Nbr** D3564 Rev D 100 0.00 FLOW WATER JET *100* Waterjet 0.00 FLOW CNC Waterjet 1-Cut as per Dwg D3564 Dwg Rev: D Prog Rev: Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 el De 14/09/11 *110* QC 0.00 Memo Quality Control

120

QC8- Inspect parts - second check

0.00

0.00

DAS

22

Quality Control

Memo

DQA:			_ Date:			•								
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UF		ork Order up	ndate only	\neg	AEROSPACE
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	-			-		Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	\neg	Other
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Root					Desc	ription of work order update	١	nitial	Acti		Sign &			
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	_	Crushing				Countersink		Misalig	gned/off center		Positioned V	Vrong -		
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		Wave/Tw	vist in Tub	e		Teit/Function		Out of 9	Sequence					

122661

Page 2

Work Order ID 122661

Tuesday, July 22, 2014 8:42:55 AM

Item ID:

Required Date: 7/21/14

D3564-13

Accept

N900040100

Setup Start

Stop

Item Name: Start Date:

Revision ID:

7/21/14

Start Qty: 12.00 Req'd Qty: 12.00

19 *12*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Stainless Steel Wearpad Fwd

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Stop

Sequence ID/ **Work Center ID** Operation Description

NC BRAKE

QC:

Set Up/ **Run Hours** Tool ID

Tool # Plan Code Accept Qty

Reject Qty

Reject Insp. Number

130

120 Brake NC

0.00

0.00

DAS 30 9-89

Stamp

DAS

Brake NC

Deburr if necessaryForm on Brake as per Dwg D3564 using Jigs DT 8179

140

140

Quality Control

QC

Memo

0.00

0.00

150

150

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

0.00

QC5- Inspect part completeness to step on W/O

FINISH TIME:

OVEN TEMPERATURE:

22 d H-D-22

DQA:			Date:						_					TRAC
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDA				_	AEROSPACE
QA Closed:			Date:							W	ork Order up	date only		· · · · · · · · · · · · · · · · · · ·
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Part N	lo.					Scrap			Machining S	Small Fab	4	d. Eng. Coor.		Quality
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	Work	Order 1		122661
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122661

Page 3

Tuesday, July 22, 2014 8:42:55 AM Accept Item ID: D3564-13 *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Stainless Steel Wearpad Fwd *12* **Start Qty: 12.00 Start Date:** 7/21/14 **Cust Item ID:** Required Date: 7/21/14 Req'd Qty: 12.00 *12* **Customer:** Reference: Start Run Date:_____ **Tooling: Approvals:** Process Plan: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Reject Reject Accept Insp. **Work Center ID** Description Qty **Run Hours** Code Qty Number Stamp 160 QC3- Inspect Part Finish 0.00 DAS 38 *160* QC 0.00 Memo **Quality Control** 170 Identify as per dwg & Stock Location: T 0.00 *170* Packaging 0.00 Memo Packaging 180 QC21- Final Inspection - Work Order Release 0.00 10/2 Afy-10,24 *120* QC 0.00 Memo Quality Control

DQA:			Date:											ART
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		Cracks				Broken/Damage/Defect		Hardwa	re		Part Incorre	cí	Temperatu	re/Cure
		Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Un	qualified	Part Lost/M	ssing	Weld	
		Cuffs				Contamination		Instruct	ions Incomplete/U	nclear	Part Moved		Wrong Sto	ck Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	Vrong		
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other	
		Inspectio	n Strip in	Tube		Drawing		Misread	i					
		Marks/Cl	hatter			Drill Holes		Off-set						
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		 Wave/Tw	vist in Tuk	e		Fit/Function		Out of S	Sequence					

Picklist Print

Tuesday, July 22, 2014 8:42:54 AM

Work Order ID: 122661

122661

Parent Item:

D3564-13

D3564-13

Parent Item Name: Stainless Steel Wearpad Fwd

Start Date: 7/21/14

Required Date: 7/21/14

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:A

New Issue 07-03-08 ec

IPP Rev:B

As per Rev C 07-07-09 JLM

IPP Rev:C

As per Rev D 07-09-09 JLM Verified By:EC Comments revised on Step 5, 6 per B44657 09-02-04 KJ

IPP Rev:D Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No		100	sf	608.0570	0.222	3			***************************************
*1/20/21/	3C / *							**			_	. mlage

IVI.3U45 I DUA

304/316 Sheet .063

Location	Loc Qty	Loc Code	
MAT020	363.057		
M127821	71.317		
▼ 1129192	14.54		
M129449	277.2		
TPI	245		
M129545	245		

Page 1

DQA:		Date:												"DART
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DART AEROSPACE LTD	Work Order:	122661
Description: Wearshoe	Part Number:	D3564-13
Inspection Dwg: D3564 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.00	+/-0.030	7.00	/		V=5kM-01	
2.432	+/-0.010	2.433	/			
3.227	+/-0.010	3.227	/			
3.500	+/-0.010	3.500				
0.300 x 0.300	+/-0.010	. 303 X.305	/			
Ø0.188	+0.005/-0.001	. 189	/			
0.063	+/-0.010	. 028				
			DAS.			

			38		
Measured by:	Di/a	Audited by:	9-89	Prototype Approval:	N/A
Date:	14/09/01	Date:	14-9-11	Date:	N/A

Rev	Date	Change	Revised by	Approved
<u> </u>	07.04.02	New Issue	KJ/JLM	
В	07.07.18	Dimensions updated per Dwg Rev. C	KJ/JLM	
_ C	08.02.28	Dwg Rev updated	KJ/DD 🚓	13/





